

Date: Friday, 23/01/2009 8:45:31 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WINDOW ASSEMBLY
 Job Number : 45168
 Estimate Number : 10304
 P.O. Number :
 This Issue : 23/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D3136043
 First Issue : / / Type : THERMOFORMING Drawing Number : D3136 REV E
 Previous Run : 43605 Project Number : N/A
 Drawing Revision : E
 Material :
 Due Date : 05/02/2009 Qty: 12 Um: Each
 Written By :
 Checked & Approved By : JUD 09.01.23
 Comment : Est Rev:A 04.02.04 New issue KJ/DS
 Est Rev.B 07.05.29 Thermoform in-house DL
 Est rev C 07.09.28 Rev E dwg EC verified by:DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MACRLICS125 1/8" Polycast II Sheet



Comment: Qty.: 3.9000 sf(s)/Unit Total : 46.8000 sf(s)
 polycast II or plexiglass G .125"

110633

HB 9-1-31

2.0 WATER JET FLOW WATER JET

F
E

HB 9-1-31



Comment: FLOW WATER JET

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 9-1-31



12

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 09/02/12 (12)

5.0 THERMOFORMING THERMOFORMING MACHINE



Comment: 1-Thermoform as per Dwg D3136 and Folio FTA002

Dwg Rev. F

Folio Rev. F

2- Engrave Part # and Batch # , and affix labels
 (D3136-3)

X
 09/02/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 23/01/2009 8:45:31 AM
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Drawing Name: WINDOW ASSEMBLY

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Part Number: D3136043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check product for scratches mal-formation or any other non conformances.

BB 09/02/12 x12

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

09-02-12 (12)

8.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

wrap in plastic.

Water sand and buff to remove scratches as required

NIA BB 09/02/13 (x12)

9.0

D31089

Decal



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part# Description Batch

2 D3108-9 Decal

334554

BB 09/02/12 (x12)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-02-12 (12)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9/2/13 (12)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-02-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <u>H5168</u>
Description: Window Assembly		Part Number: D3136-043
Inspection Dwg: D3136	Rev: E	Page 1 of 1

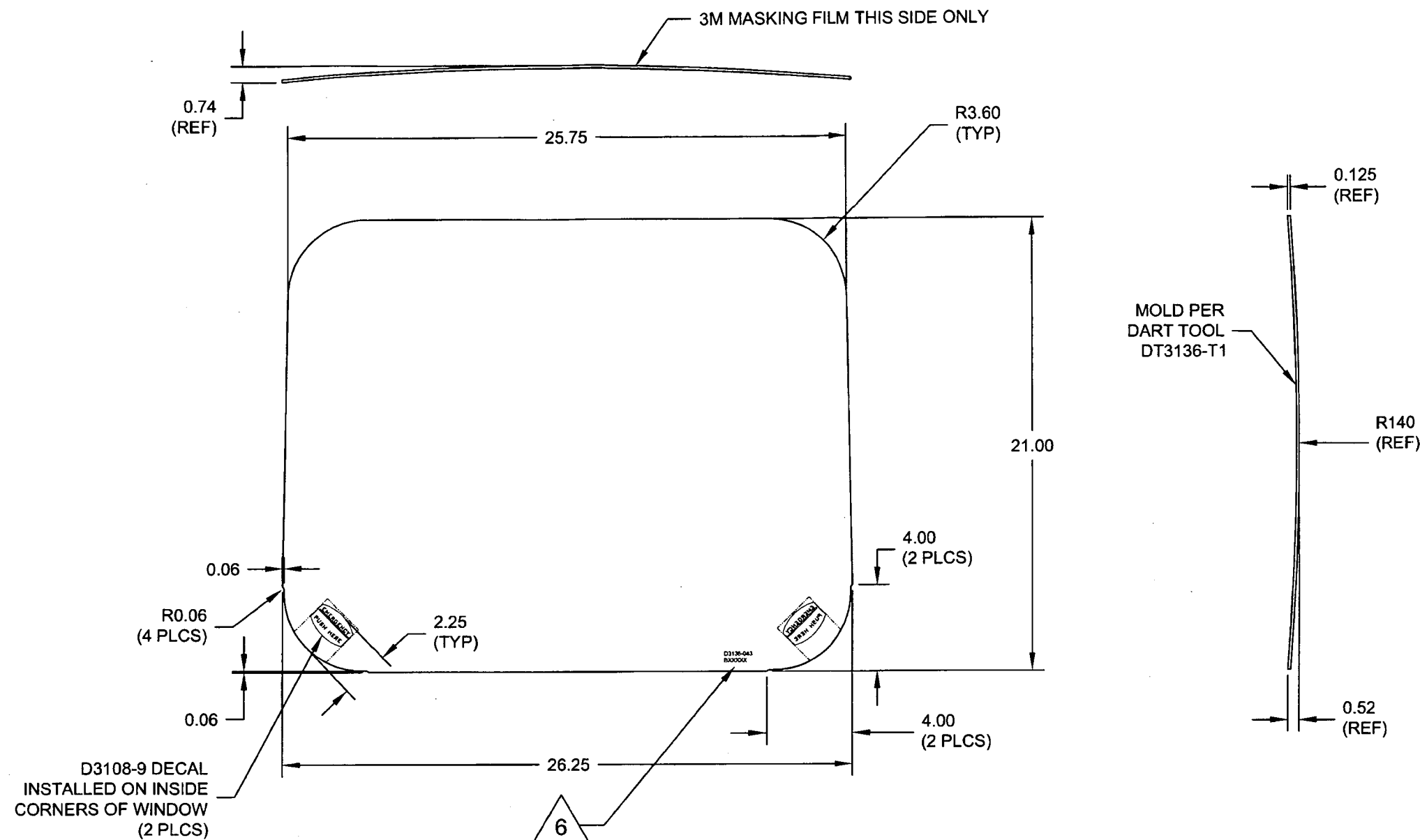
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.00	+/-0.030	21.00	X			
25.75	+/-0.030	25.75	X			
26.25	+/-0.030	26.25	X			
1.125	+/- .00	1.128	X			

Measured by: <u>RB</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: <u>9-1-31</u>	Date: <u>09/02/12</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	<u>[Signature]</u>



D3136-3 WINDOW
D3136-043 WINDOW ASSEMBLY
 (INCLUDES D3108-9 DECALS)

- NOTES:**
- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET FER MIL-P-5425 OR PLEXIGLAS G
 CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) REMOVE SHARP EDGES
 - 6) IDENTIFICATION: ENGRAVE P/N "D3136-043" AND B/N ON LOWER EDGE
 USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
 - 7) WEIGHT: 2.61 +/- 0.58 LBS
 - 8) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
 b) DRAPE OVER D3136-T1 MOLD & CLAMP
 c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

RELEASED
 07.09.22
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 45168

DESIGN	4	DART AEROSPACE LTD	
DRAWN	JC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JC	DRAWING NO.	REV. E
MFG. APPR.	JC	D3136	SHEET 2 OF 2
APPROVED	JC	TITLE	SCALE
DE APPR.	JC	WINDOW ASSEMBLY	1:6
DATE	07.09.10	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	